

Date: Monday, 12/01/2009 2:37:21 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WASHER
<b>Job Number</b> : 44670	
<b>Estimate Number</b> : 13003	
<b>P.O. Number</b> :	<b>Part Number</b> : D36311
<b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3631 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 41141	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 02/02/2009 <b>Qty:</b> <sup>100</sup> / <sub>60</sub> <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.01.13</u>	
<b>Comment</b> : Est Rev:A New Issue 07-07-28 JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7969

Purchase Part Number: 95606A170

Supplier: Mc Master Carr

Certificate of conformity is required

C20910114(100)

2.0	95606A170	Washer
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)  
 WASHER

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

12/9/16 (100)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECKS 0910119 (x100) counters

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST 11588

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:37:21 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 44670

Part Number: D36311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/21 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 09.01.20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3631</b>	REV. A SHEET 1 OF 1
DATE <b>07.05.16</b>		TITLE <b>WASHER</b>	SCALE NTS
REV <b>A</b>	DATE <b>07.05.16</b>	DESCRIPTION <b>NEW ISSUE</b>	

## SPECIFICATION CONTROL DRAWING



**D3631-X WASHER**

**RELEASED**  
07.08.02 **[Signature]**

PART NUMBER	OD	ID	THICKNESS	MATERIAL	SUPPLIER
D3631-1	0.688	0.500	0.031	NYLON	McMASTER-CARR P/N: 95606A170

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY  
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WORK ORDER  
NO. **14670**

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Purchase Order  
PO00007969

Page 1 of 2

200 Aurora Industrial Pkwy  
Aurora, OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

McMaster-Carr Number  
2321700-01

01/15/2009

Line	Description	Ordered	Shipped	LNS	A11
1	92311A564 Type 18-8 Stainless Steel Cup Point Socket Set Screw, 1/4"-28 Thread, 1" Length, Packs of 50	2 Packs	2	2 - 699 - 04	06 - 67 A564 2PK 1
2	95606A170 Nylon 6/6 Small-OD Flat Washer, 7/16" Screw Size, 1/2" ID, 11/16" OD, .028"-.034" Thickness, Packs of 100	1 Pack	1	2 - 623	2
3	6605K51 Hook and Loop Cable Tie, Black Flame-Retardant Wrap Around 6" Length, 1" Width, Packs of 10	1 Pack	1	3 - 119	3
4	8509A12 Removable Drill Bushing for Thin Gauge Material, 30 (.1285") ID, 3/8" OD, 3/8"-24 Thread Size	60 Each	✓ 60	2 - 494	4
5	8509A31 Lock Ring, 1/2" OD, for 8509a11-15, A41-43, Removable Drill Bushing for Thin Gauge Material	60 Each	✓ 60	2 - 495	5
6	8491A087 Steel Press-Fit Drill Bushing/Liner, 0.191" (11) ID, 5/16" OD, 1/2" Length	10 Each	10	2 - 495	6
7	8491A071 Steel Press-Fit Drill Bushing/Liner, 0.098" (40) ID, 1/4" OD, 1/2" Length	8 Each	✓ 8	2 - 494	7

Dart Aerospace Ltd

Assembly  
Area

11

Cycle

11

Shelf

118

Documents

4

55-R-0707

EXP

3 lbs  
9 lines

FW1WBP24  
01/15/2009  
07:00/07:42  
023

